

Date: Thursday, 31/07/2008 12:17:54 PM  
 User: Julie Lecocq

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT
Job Number	40844	Part Number	D2565101
Estimate Number	10273	Drawing Number	D2565 REV E
P.O. Number		Project Number	N/A
This Issue	31/07/2008	S.O. No.	
Prsht Rev.	NC	Drawing Revision	E
First Issue	11	Material	
Previous Run	38027	Due Date	07/08/2008
Written By		Qty:	<10
Checked & Approved By	JUL 08.8.01	Um:	Each
Comment	Est: F 02.04.16 Added dwg Rev.C1 NG		

## Additional Product

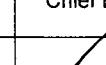
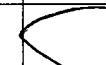
Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		 <b>Comment:</b> Qty.: 1.7955 f(s)/Unit Total : 17.9550 f(s) 304 RD TUBE .750 X.49W Material: 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall per Dwg (M304TR0750W049) Batch <b>M 107 098 ① M 108 498 ⑧ M 107 688 ⑩</b>
2.0	BRAKE NC	NC BRAKE
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 <b>Comment:</b> NC BRAKE Punch as per Dwg D2565 using DT 8313 <b>SB 08/08/27 ⑩</b>
4.0	QC5	INSPECT WORK TO CURRENT STEP
		 <b>Comment:</b> INSPECT WORK TO CURRENT STEP <b>SB 08/08/23 ⑨</b>
5.0	POWDER COATING	POWDER COATING
		 <b>Comment:</b> POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <b>7:30</b> OVEN TEMPERATURE: <b>400°</b> FINISH TIME: <b>8:00</b> <b>M 1 08/09/24</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2565-101 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/09/28  
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/23	2 3	Small dent found during cleaning  RC from not handling: storage.	 08/09/23	Scrap and Destroy <del>and replace</del> <del>RC</del>	08/09/24 HJM	 08/09/23	 HJM	 08/09/23

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40844

Part Number: D2565101

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8/9/24

SI

7.0 PACKAGING 1

PACKAGING RESOURCE #1



9/1

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 270

8/9/24

SI

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

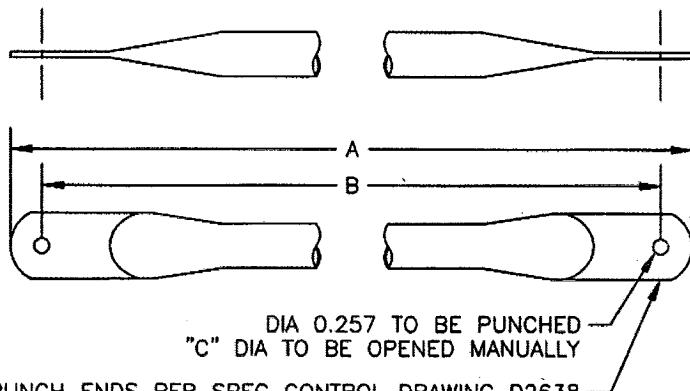
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**COPY IS  
ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2565	SHEET 1 OF 1
DATE		TITLE	SCALE
04.05.05		STRUT	1:3

**RELEASED**  
04 05.05

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

SHOP COPY

RETURN TO

ENGINEERING

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL UNCONTROLLED COPY  
(REF. DART SPEC. M304TR0.750W0.049) SUBJECT TO AMENDMENT  
ENSURE SEAMLESS TUBE IS USED WITHOUT NOTICE
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 WORK ORDER
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED NO. 40844
- 4) ALL DIMENSIONS ARE IN INCHES

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